

Work Order ID 84233

84233

Page 1

May-08-12 10:35:01 AM

Item ID: D3914-7 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Rib
 Start Date: 08/05/2012 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 22/05/2012 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/08 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3914 | B |

100 0.00

100

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D3914
 2- debur and remove identification markings

6 SAD 12-05-08

110 QC6- Inspect dimensions to drawing 0.00

110

QC

Memo

0.00

Quality Control

6x SD 12.05.08

120 Identify as per dwg & Stock Location: _____ 0.00

120

Packaging

Memo

0.00

Packaging

6x SD 12.05.08

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 84233

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May-08-12 10:35:01 AM

Item ID: D3914-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Rib

Stop *NS2*

Start Date: 08/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/5/98

MF

12-05-08

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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NOTE: Date & initial all entries

Picklist Print

May-08-12 10:35:04 AM

Page 1

Work Order ID: 84233

84233

Parent Item: D3914-7

D3914-7

Parent Item Name: Rib

Start Date: 08/05/2012

Required Date: 22/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as
per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 11.01.18 chg
qc5 to 6 DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TS0.500W.049 | | Purchased | No | | | 100 | f | 699.3224 | 7.875 | 49.73684 | | | |

M304TS0 500W 049

Square Tubing

**

SAJ 12-05-08

Location

Loc Qty

Loc Code

MAT034

699.3224093

118460

0.00001534

121328

167.492194

121565

531.8302

49.7369

| W/O: | | WORK ORDER CHANGES | | | | | | |
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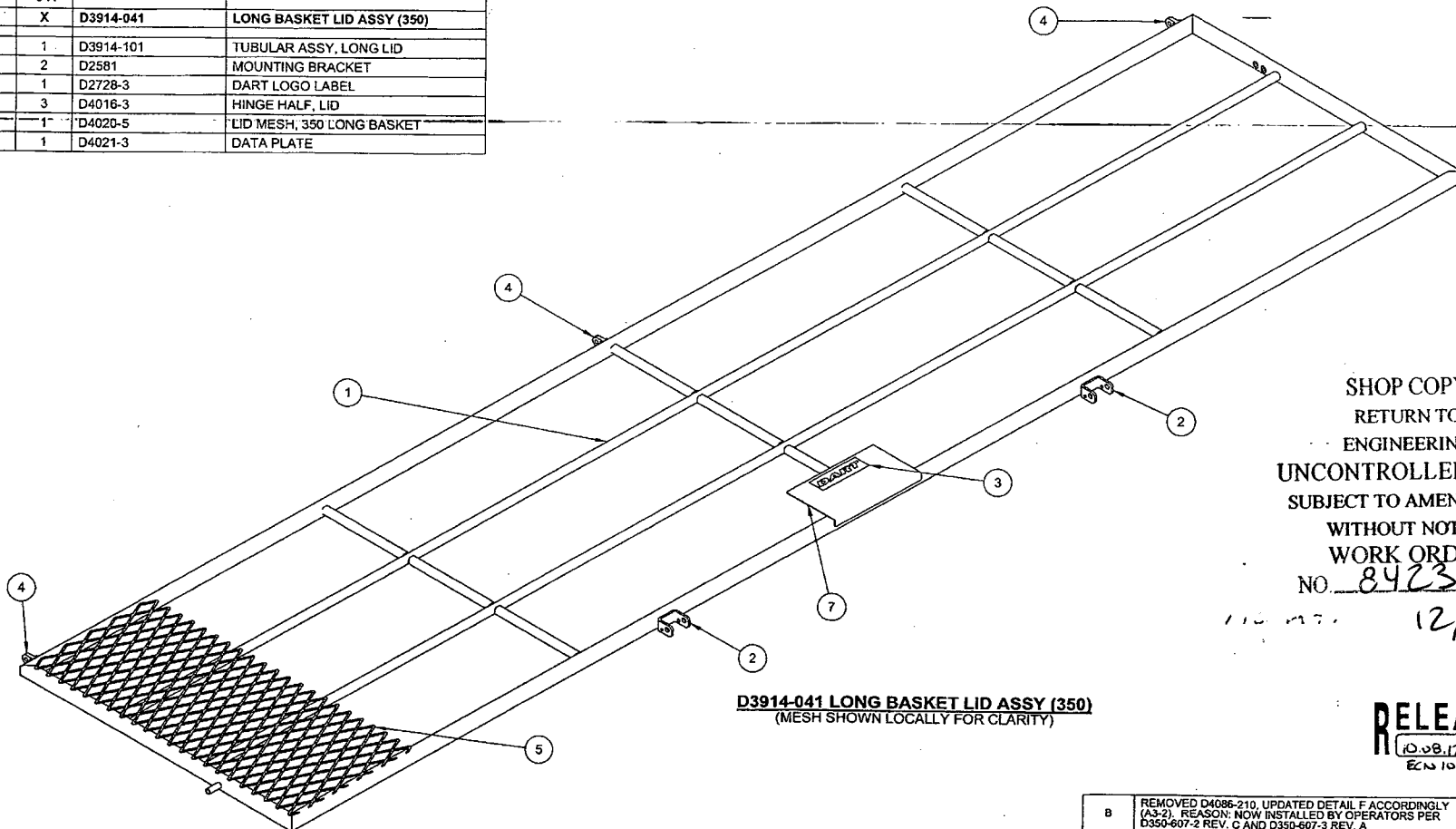
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NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|----------------------------|
| | X | D3914-041 | LONG BASKET LID ASSY (350) |
| 1 | 1 | D3914-101 | TUBULAR ASSY, LONG LID |
| 2 | 2 | D2581 | MOUNTING BRACKET |
| 3 | 1 | D2728-3 | DART LOGO LABEL |
| 4 | 3 | D4016-3 | HINGE HALF, LID |
| 6 | 1 | D4020-5 | LID MESH, 350 LONG BASKET |
| 7 | 1 | D4021-3 | DATA PLATE |



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84233 MLW
110 117. 12/05/08

RELEASED
10.08.17 9
ECN 10-596

| | | | |
|------------|---|---|--------------|
| B | REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A. | MB | 10.08.05 |
| A | NEW ISSUE | JPH | 10.03.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | ALS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | SC | DRAWING NO. | REV. B |
| MFG. APPR. | SC | D3914 | SHEET 1 OF 4 |
| APPROVED | SC | TITLE | SCALE |
| DE APPR. | SC | LONG BASKET LID ASSY (350) | NTS |
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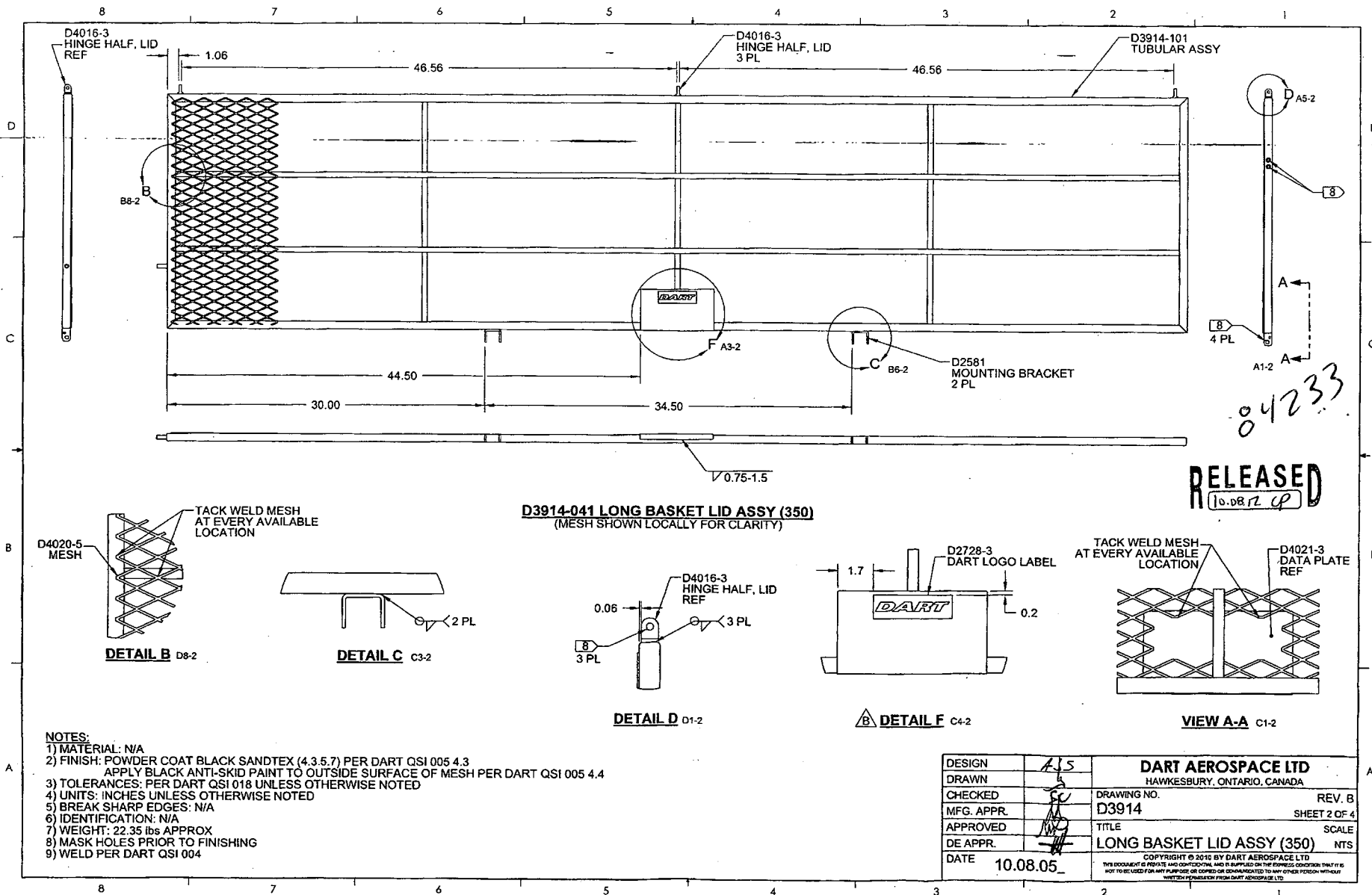
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

| | | | |
|------------|----------|---|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | SC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | MD | DRAWING NO. | REV. B |
| MFG. APPR. | | D3914 | SHEET 2 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET LID ASSY (350) | NTS |
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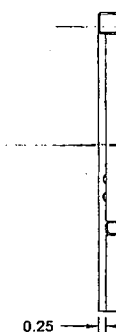
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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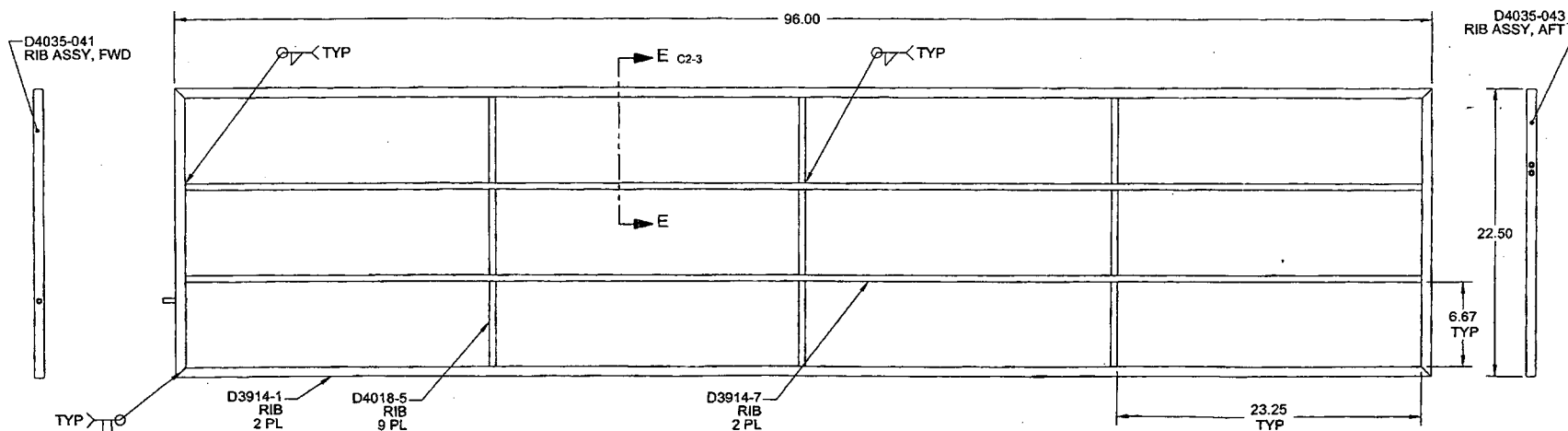
NOTE: Date & initial all entries

| ITEM | QTY -101 | P/N | DESCRIPTION |
|------|-------------|-----------|------------------------------|
| | X | D3914-101 | TUBULAR ASSY, LONG LID (350) |
| 1 | 2 | D3914-1 | RIB |
| 2 | 2 | D3914-7 | RIB |
| 3 | 9 | D4018-5 | RIB |
| 4 | 1 | D4035-041 | BASKET LID RIB ASSY, FWD |
| 5 | 1 | D4035-043 | BASKET LID RIB ASSY, AFT |



SECTION E-E CS-3

84233



RELEASED
10-08-12

8 D3914-101 TUBULAR ASSY, LONG LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

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| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RC | DRAWING NO. | REV. B |
| MFG. APPR. | WJ | D3914 | SHEET 3 OF 4 |
| APPROVED | WJ | TITLE | SCALE |
| DE APPR. | WJ | LONG BASKET LID ASSY (350) NTS | |
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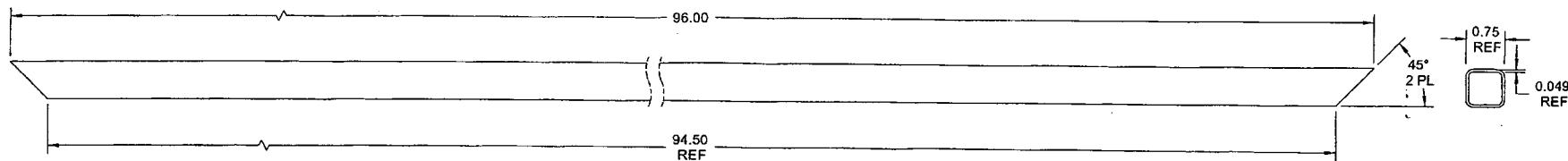
| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

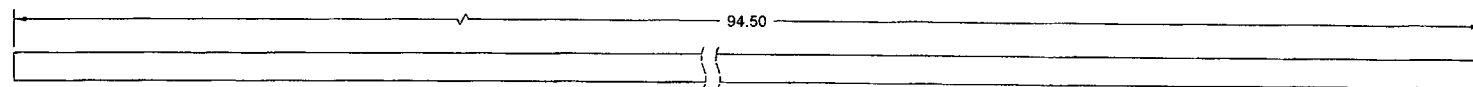
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NOTE: Date & initial all entries



D3914-1 RIB

84233



D3914-7 RIB

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.17.04

| | | | |
|------------|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | SC | DRAWING NO. | REV. B |
| MFG. APPR. | WJP | D3914 | SHEET 4 OF 4 |
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